

Work Order ID 164313

Monday, July 17, 2017 1:47:55 PM

649.5214

B 164313

REV. A

164313

Page 1

Item ID: 649.5214

Revision ID:

Item Name: Bracket

Start Date: 7/24/2017 Start Qty: 4.00

Required Date: 8/18/2017 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

JUL 17 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
649.5200	A

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blanks at 3.00"

0.00

0.00

4

S.C. 7/17/17 DAS 45 9-89

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB233

DWG REV: A

FOLIO REV: A

0.00

0.83

4

S.C. 7/17/17 DAS 45 9-89

2- deburr and break all sharp edges

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 164313

Monday, July 17, 2017 1:47:55 PM

164313

Page 2

Item ID: 649.5214

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 7/24/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/18/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O to ATG : <u>27223</u>								
	1- Black Anodize as per Dwg 649.5200								
	2- PRIME AS PER DWG, SEE NOTE #2								
	Certification of Comformity is required								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Work Order ID 164313

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Page 3

Item ID: 649.5214

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 7/24/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/18/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.00

Packaging

4 **DAS**
8-8-17 **AUG 18 2017**

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

*2.5 mils thickness primer*4 **DAS**
38
8-8-17 **AUG 22 2017**

170

Identify as per dwg & Stock Location

0.00

170

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

4 **DAS**
6
8-8-17 **AUG 22 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Work Order ID 164313

Monday, July 17, 2017 1:47:55 PM

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Page 4

Item ID: 649.5214

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 7/24/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/18/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

DAS
21
9-88

UM 17/8/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, July 17, 2017 1:48:03 PM

Page 1

Work Order ID: 164313

164313

Parent Item: 649.5214

649 5214

Parent Item Name: Bracket

Start Date: 7/24/2017

Required Date: 8/18/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A RQ 13/11/26 New issue VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
649.5200E		Purchased		No		100	f	134.9160	0.25	1.052632			

649 5200F

**

Bracket

Location

Loc Qty

Loc Code

MAT034

134.916

92578

134.916

1.053 ~~1.053~~ SC 11/17/17 DAS 45 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																												
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Misidentified ☐	Past Due ☐																																																															

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03696				SHEET 1 OF 1	
	DWG NO. 649.5200	REV: A	PREPARED BY B. PETERS	DATE: 11/14/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: BRACKET					
	APPROVED BY:	ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED ALTERNATE MATERIAL.				ECR: D-12-004	SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 164313M

SHEET 1, ZONE A2 IS:

⚠ MATERIAL: 7075-T651 ALUMINUM PER AMS-QQ-A-250/12.

IS

- ⚠ ALTERNATE MATERIAL: 0.125 INCH THICK 2024-T3 ALUMINUM SHEET METAL.
 ⚠ ALTERNATE MATERIAL: 7075-T6511 ALUMINUM PER AMS-QQ-A-200/11.

SHEET 1, ZONE B1 IS:

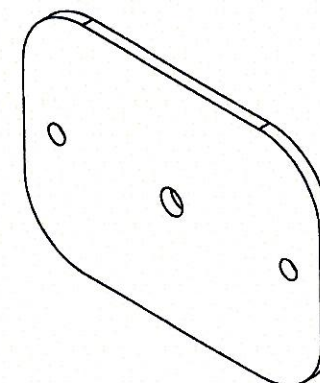
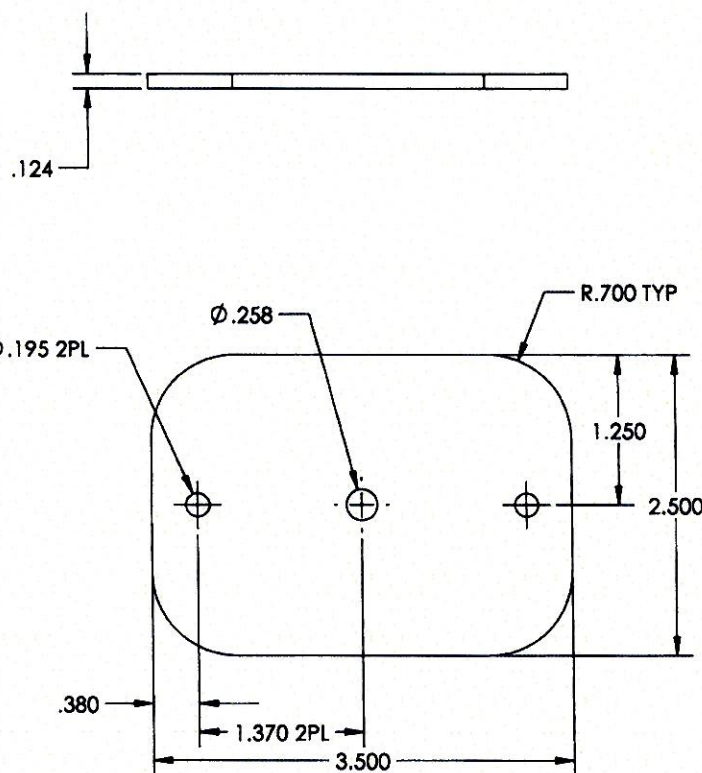
5	R	649.5214			BRACKET	⚠ ⚠	⚠ ⚠
4	R	649.5213			DOUBLER	⚠ ⚠	⚠
3	R	649.5212			BRACKET	⚠ ⚠	⚠ ⚠
2	R	649.5211			SHIM	⚠ ⚠	⚠
1	R	649.5210			DOUBLER	⚠ ⚠	⚠
F/N	TC	PART NUMBER	QTY		DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED: ☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☒ BOM						CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO

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NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR: BLACK; PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J TYPE I, CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120. LASER ENGRAVE CENTURY GOTHIC, 12 POINT P/N AND REVISION.
5. PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5212 BRACKET.SLDPRT, LAST MODIFIED 11-02-11.
6. PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5214 BRACKET.SLDPRY, LAST MODIFIED 11-02-11.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PRT		NA
N/C	INITIAL RELEASE	11-02-11	P. BRAVO
A	INCORPORATED ECH 03488	06-07-12	P. BRAVO



649.5210

UNINCORPORATED ECN(s)

03696

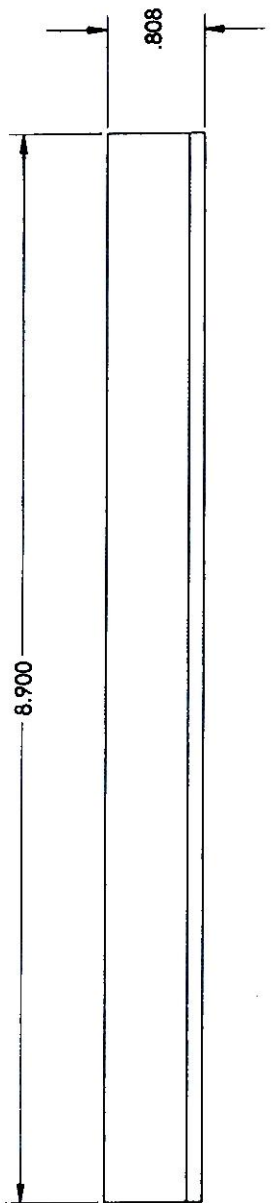
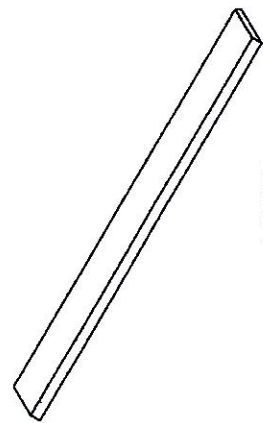
	5	649.5214	BRACKET	△	△△
	4	649.5213	DOUBLER	△	△
	3	649.5212	BRACKET	△	△△
	2	649.5211	SHIM	△	△
	1	649.5210	DOUBLER	△	△
	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

QTY	PARTS LIST			
NEXT ASSY (S)	APICAL INDUSTRIES			
649.4700	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
	BRACKET			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°			
	REV	CAGE CODE	OWG NO	REV
	8	07ME6	649.5200	
	SCALE	NONE	SHEET	1 OF 4

2
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3 4 5 6 7 8

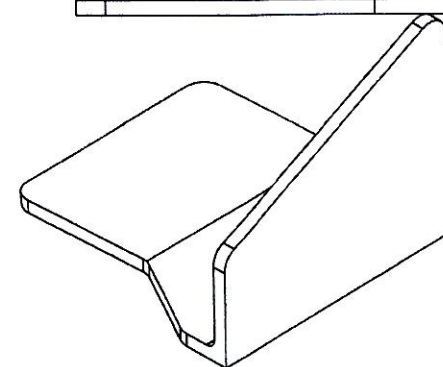
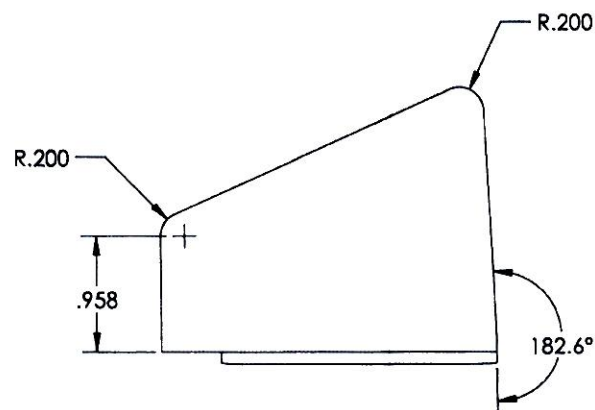
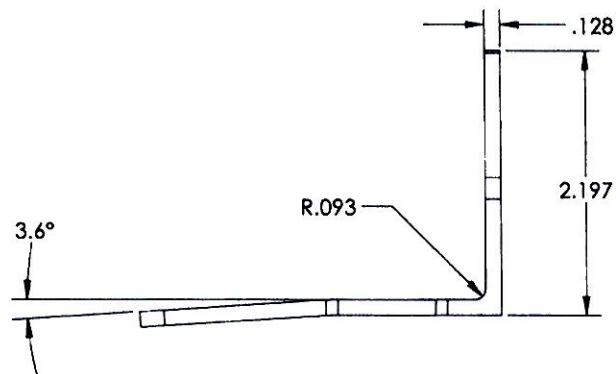
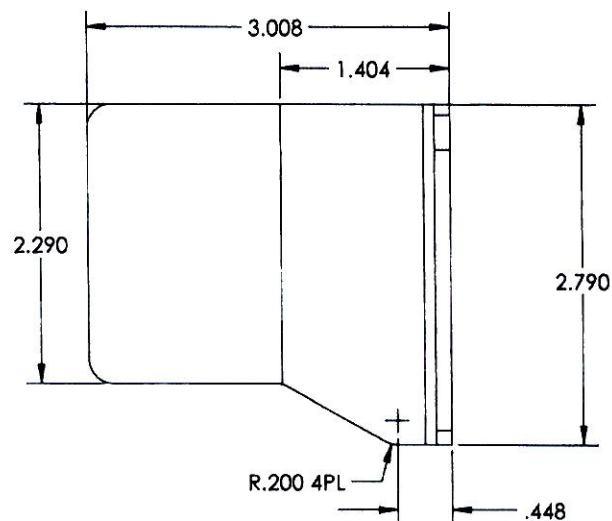
REV	DESCRIPTION	DATE	APPROVED



APICAL INDUSTRIES 2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92054-3312 (760) 724-5300	
BRACKET	
DESIGNED BY: LRL/1 DRAWN BY: CHERIE CHECKED BY: JIMMY IN CHARGE: JIMMY DATE: 11/11/11 REVISIONS:	REF: CAD FILE: 649.5211.DWG S: D7/12/15 SCALE: NONE
PARTS LIST: PART NO. PART NAME 649.5211 BRACKET	REV: A SHEET: 2 OF 4

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REVIEWS			
REV.	DESCRIPTION	DATE	APPROVED

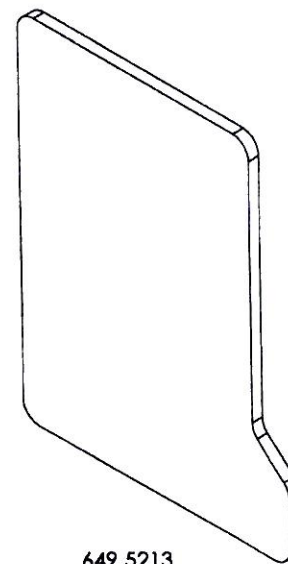
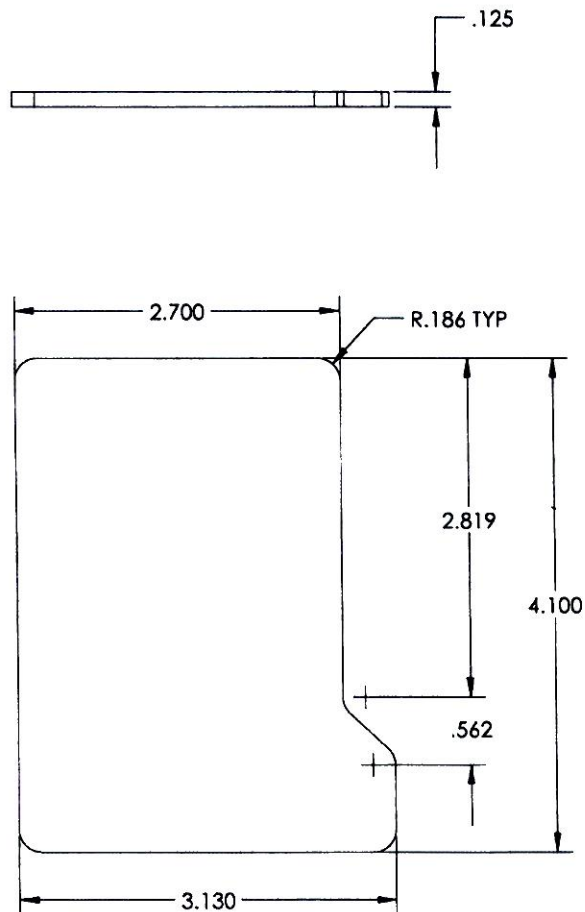


649.5212 SHOWN
649.5214 OPPOSITE

ORIGINAL DATE (MOD-DATE) 11-02-11		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWN BY A. QUINN	CHECKED BY P. BRAYO		
DRAWING APPROVAL P. BRAYO (11-02-11)	CONTRACT NO.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SIX B	REV A
SCALE NONE		CAGE CODE 07M26	DWG NO. 649.5200
SHEET 3 OF 4		BRACKET	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE 11-02-11		APICAL INDUSTRIES	
DRAWN BY A. GUAN		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY P. BRAVO		BRACKET	
DRAWING APPROVAL 11-02-11			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		REV B	REV A
SCALE NONE		SHEET 4 OF 4	



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913715

Date: 18-Aug-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms

Ship Via

Quantity

Description

Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.

4

ea

Part: 649.5214

Rev: A

Bracket

Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils)
Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing.

Job: 21454

PO: PO37223

Line: 11

OAS
38
9-89

4

ea

Part: 649.5212

Rev: A

Bracket

Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils)
Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing.

Job: 21455

PO: PO37223

Line: 12

8

ea

Part: 649.4814

Rev: B

Doubler

Job: 21456

PO: PO37223

Line: 13

10

ea

Part: 649.5213

Rev: A

Doubler

Job: 21458

PO: PO37223

Line: 15

4

ea

Part: D5156-5

Rev: B

Face Plate

Black Anodize per MIL-A-8625F, Type II, Class 2, .000007-.0010" (.07 - 1 mils)

Job: 21463

PO: PO37223

Line: 20

CERTIFICATE OF CONFORMANCE

A.T.G. Industries Inc. certifies that all items in this shipment conform to the requirements.

Date:

18/8/17

Certified Signature:

[Signature]

Made in Canada.

AUG 18 2017



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37223**

Purchase Order Date 7/26/2017

PO Print Date 7/28/2017

Page Number 4 of 8

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

10 164270

649.4816 Doubler

7/26/2017

Yes

7/26/2017

Hard Anodize and Prime as per
Dwg 649.4800 REV B

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

AUG 15 2017

Line Total:

11 164313

649.5214 Bracket

7/26/2017

Yes

7/26/2017

Black Anodize and Prime as per
Dwg 649.5200 REV.A

4.00

Line Total:

12 164314

649.5212 Bracket

7/26/2017

Yes

7/26/2017

Black anodize and Prime as per
Dwg 649.5200 REV.A

4.00

Line Total:

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

AUG 18 2017 DAS
6
9-89

DAS
38
9-89

7/28/2017